

Work Order ID 61945-2
Monday, September 13, 2010 8:18:41 AM

PRELIMINARY ISSUE

Inc 0101

Page 1

Item ID: D4172-10
Revision ID: PRELIM
Item Name: Angle
Start Date: 9/10/2010
Required Date: 9/17/2010
Reference:

Accept



Setup Start



Stop



Start Qty: 6.00



Req'd Qty: 6.00



Cust Item ID:

Customer:

Approvals: Process Plan:
QC:

H

Date: 10-9-13

Tooling:

Date:

Run Start



Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4172

PA1

100

0.00



Small Fab

Small Fab

Memo

0.00

- 1- Cut to length as per dwg
- 2- Use DT9663 to drill holes in angle, open to size as per dwg
- 3- Deburr holes

9/10/09/16 ©

110



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00 - inspecting to PA1

Memo

0.00

Dry only
Scoloslu (X6)

120



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10/09/16

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61945

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Page 2

Item ID: D4172-10

Revision ID: PRELIM

Item Name: Angle

Start Date: 9/10/2010 Start Qty: 6.00

Required Date: 9/17/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

10-9-16

Memo

0.00

6

7

composites
CA

Ian

140



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Ian

Memo

0.00

10-10-01

150



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/04

POSITIVE RECALL

EFFECTIVE 10/9/04 AUTH

RELEASED DATE 10/10/04

PBR Release Date

DATED 10.09.04

10-10-01

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Picklist Print

Monday, September 13, 2010 8:18:45 AM

Page 1

Work Order ID: 61945



Parent Item: D4172-10

Parent Item Name: Angle

Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.09.09 new issue DD ver:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6203



Angle Extrusion

Manufactured No

100

f

9.5000

0.0625

0.394737



Location

Loc Qty

Loc Code

MAT

9.5

45501

9.5

Handwritten: 9/10/09/15
0.394737

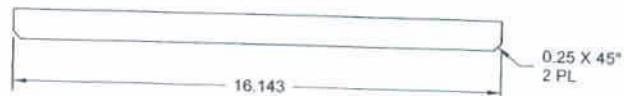
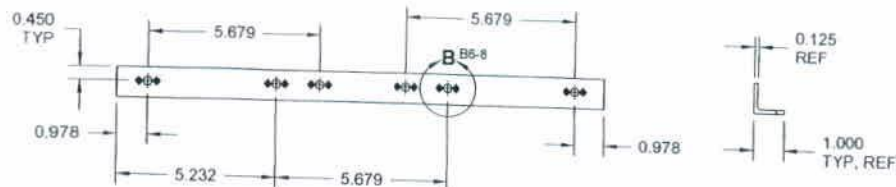
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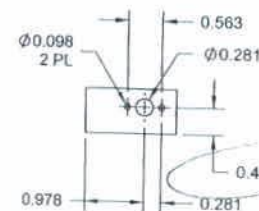
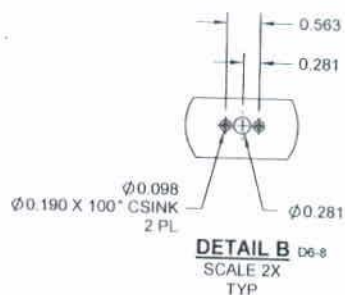
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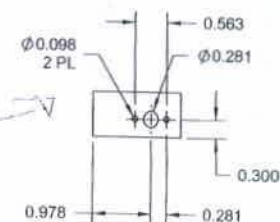
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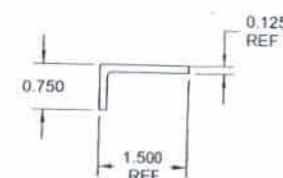
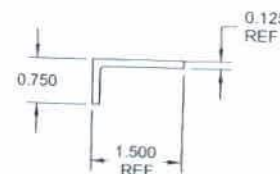
D4172-7 CROSSBAR



D4172-9 ANGLE



D4172-10 ANGLE



NOTES:

- 1) MATERIAL
D4172-7: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.00 X 1.00 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M8061T6A OR D6207
D4172-9/-10: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 1.50 X 1.50 X 0.125 THICK
PER AMS-QQ-A-200/8
REF. DART SPEC. M8061T6A OR D6207
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D4172-7 = 0.14 lbs; D4172-9/-10 = 0.01 lbs EACH

PRELIMINARY ISSUE
10.09.08

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG APPR.		D4172	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR		POD MOUNTING FRAME ASSY	NTS
DATE	10.09.03	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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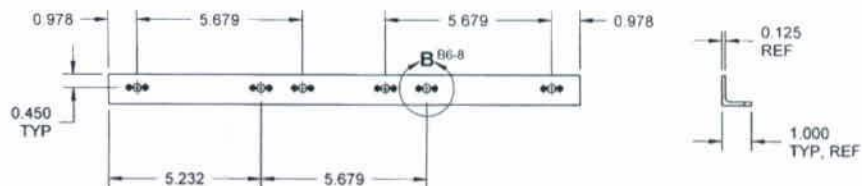
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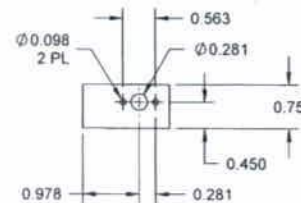
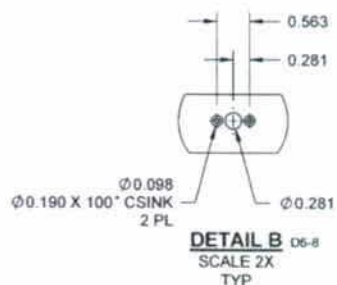
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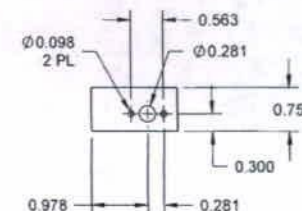
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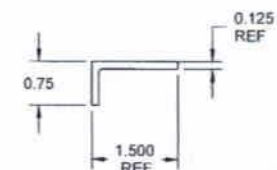
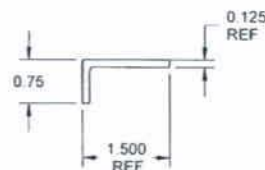
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D4172-10 ANGLE



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PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A OR D6203
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4172-7 = 0.14 lbs, D4172-9/-10 = 0.01 lbs EACH

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61945

RELEASED
2010-09-29